

BLUE

23

Date: Wednesday, 5/16/2007 8:13:23 AM
By: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32376
Estimate Number : 10318
P.O. Number : NIA
This Issue : 5/16/2007 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NIA Type : PURCHASED PARTS
Previous Run : 32018
Written By :
Checked & Approved By :
Comment : Est. D 02:09.20 Re-format; Incorporated D2657; D2658 KJ/RF

Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
Part Number : D2659^{up}
Drawing Number : D2659 REV A
Project Number : N/A
Drawing Revision : A
Material : NIA
Due Date : 6/6/2007 Qty: 32 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 32376A LUG



26
26 x B32018



Comment: Sub-Component LUG

D2657 B 2X B29228 A

FC 07/06/22

28

2.0 32376B LUG BRACKET



Comment: Sub-Component LUG BRACKET

D2658 B 32376B

FC 07/06/22

28

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484

A/RSteel Rod M103794

SP 07/06/22

28

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/25

28

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/25

28

6.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/19	1	split to send to outside supplier for print	U	07/06/19	4	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:23 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 32376

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

-CLEAR DELFLEET

7.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock updated

57433

07/7/5 (16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



(change to 'up' in keepc)

07.07.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

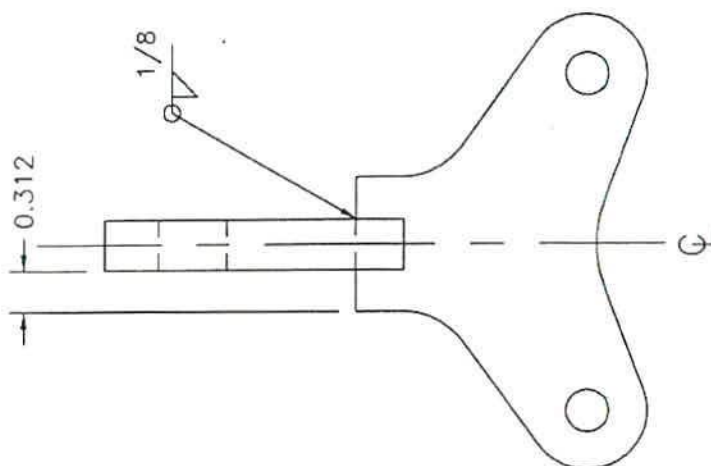
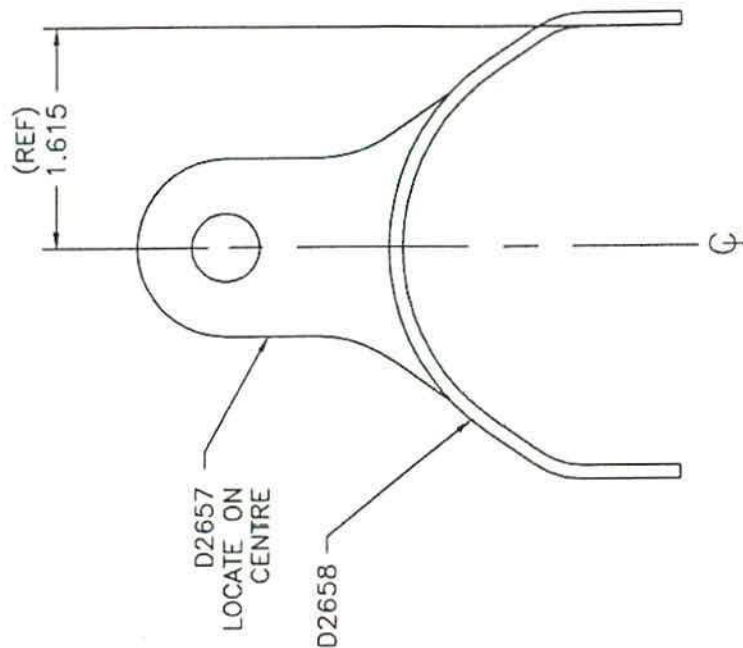
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (Φ)

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32376